

Work Order ID 80227

February-15-12 7:56:52 AM

\*80227\*

Page 1

Item ID: D3939-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Cover

Start Date: 2/15/12

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 2/16/12

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3939

Rev. A

100

0.00

\*100\*

FLOW WATER JET

0.00

12/02/15

2

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

0.00

12/02/15

2

QC

Memo

Quality Control

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**\*80227\***

Page 2

Item ID: D3939-3

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Setup Start **\*NS1\***

Revision ID:

Item Name: Cover

Stop **\*NS2\***

Start Date: 2/15/12

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/16/12

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

**\*140\***

QC

Memo

0.00

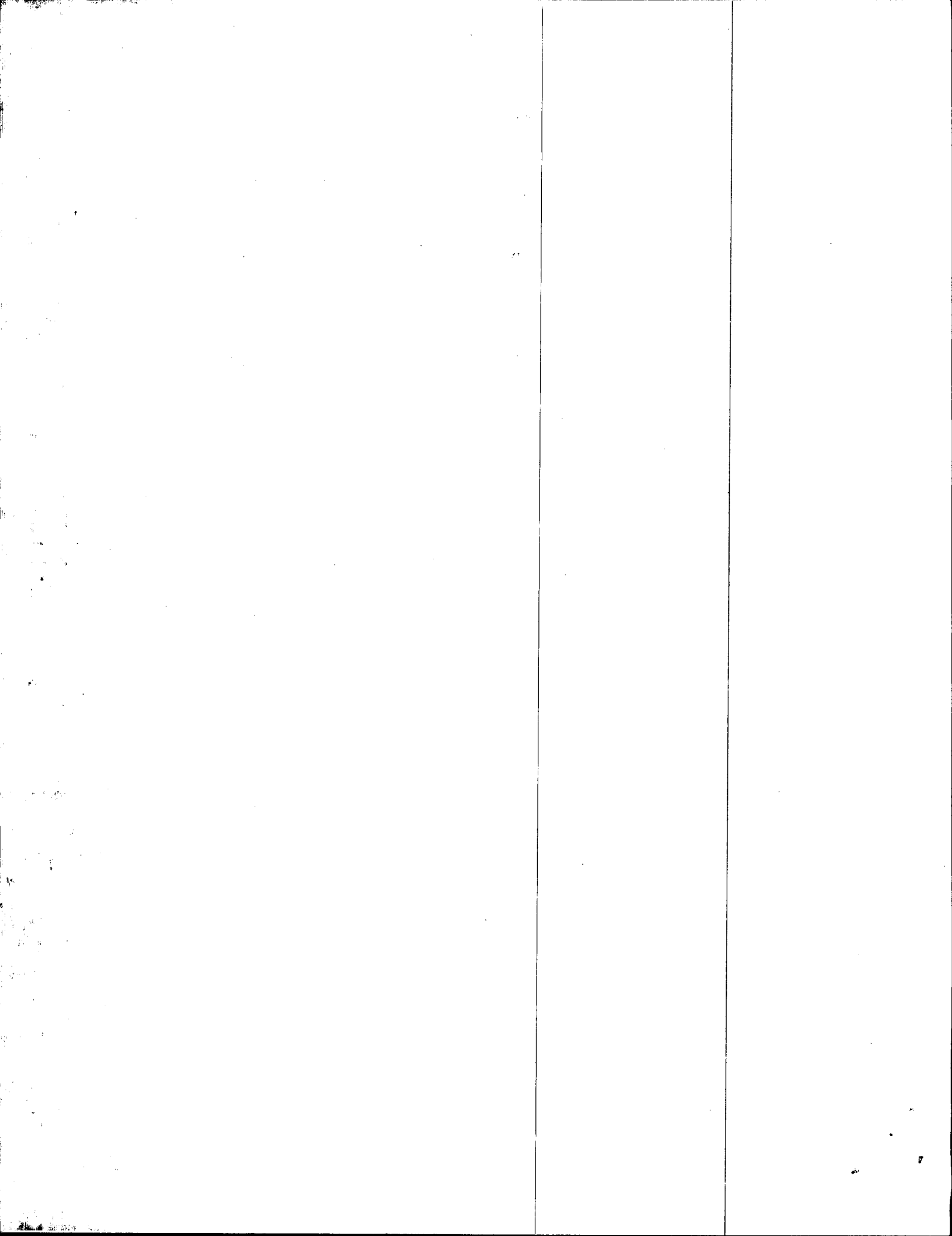
Quality Control

(12)

(2)

CF 12-2-16

2 H 12-7-16



# Work Order ID 80227

**\*80227\***

February-15-12 7:56:52 AM

Item ID: D3939-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Cover

Start Date: 2/15/12

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/16/12

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

12/2/14 SP 2

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/2/17

ME 12.02.17

# Picklist Print

February-15-12 7:56:52 AM

Page 1

Work Order ID: 80227

Parent Item: D3939-3

Parent Item Name: Cover

Start Date: 2/15/12

Required Date: 2/16/12

Start Qty: 2.00

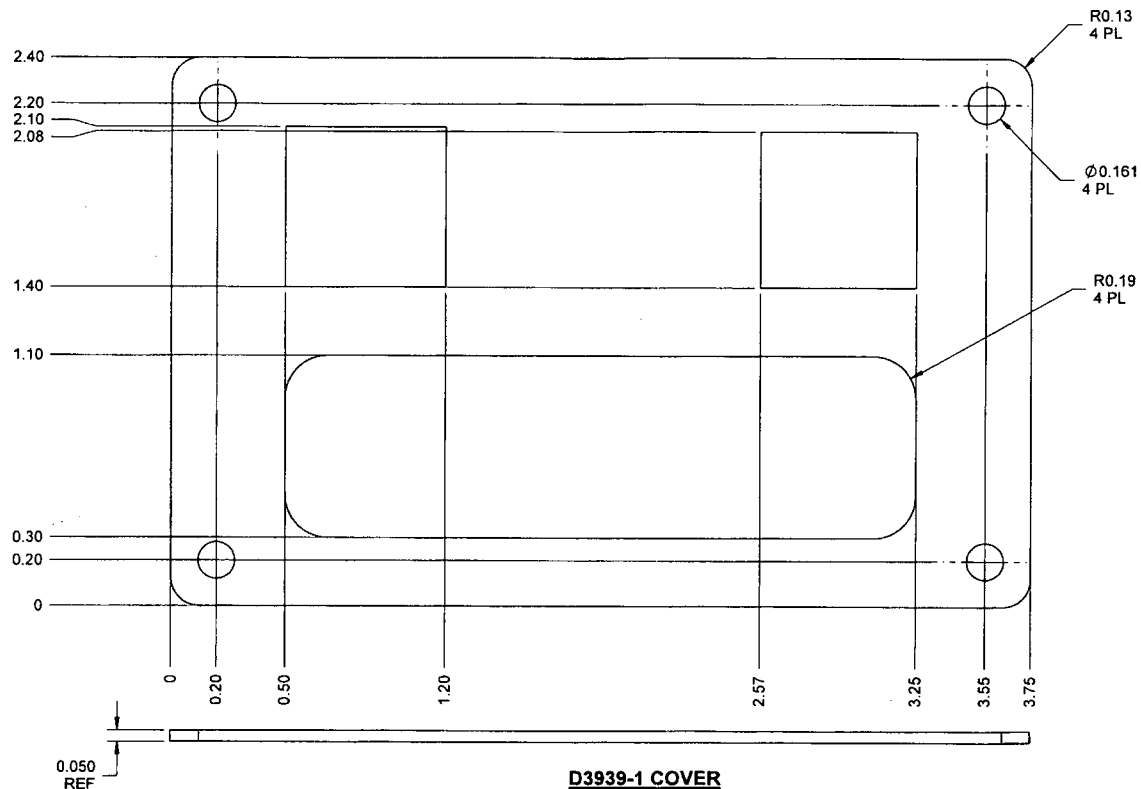
Required Qty: 2.00

Comments: IPP REV:A 12.02.15 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	114.3600	0.0625	0.1315789			
6061-T6 .050 Sheet													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	114.36	
113216	10	
114799	89.36	
114993	15	

0.2 ~~2~~ 12/02/15



**D3939-1 COVER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

*W/B0222*

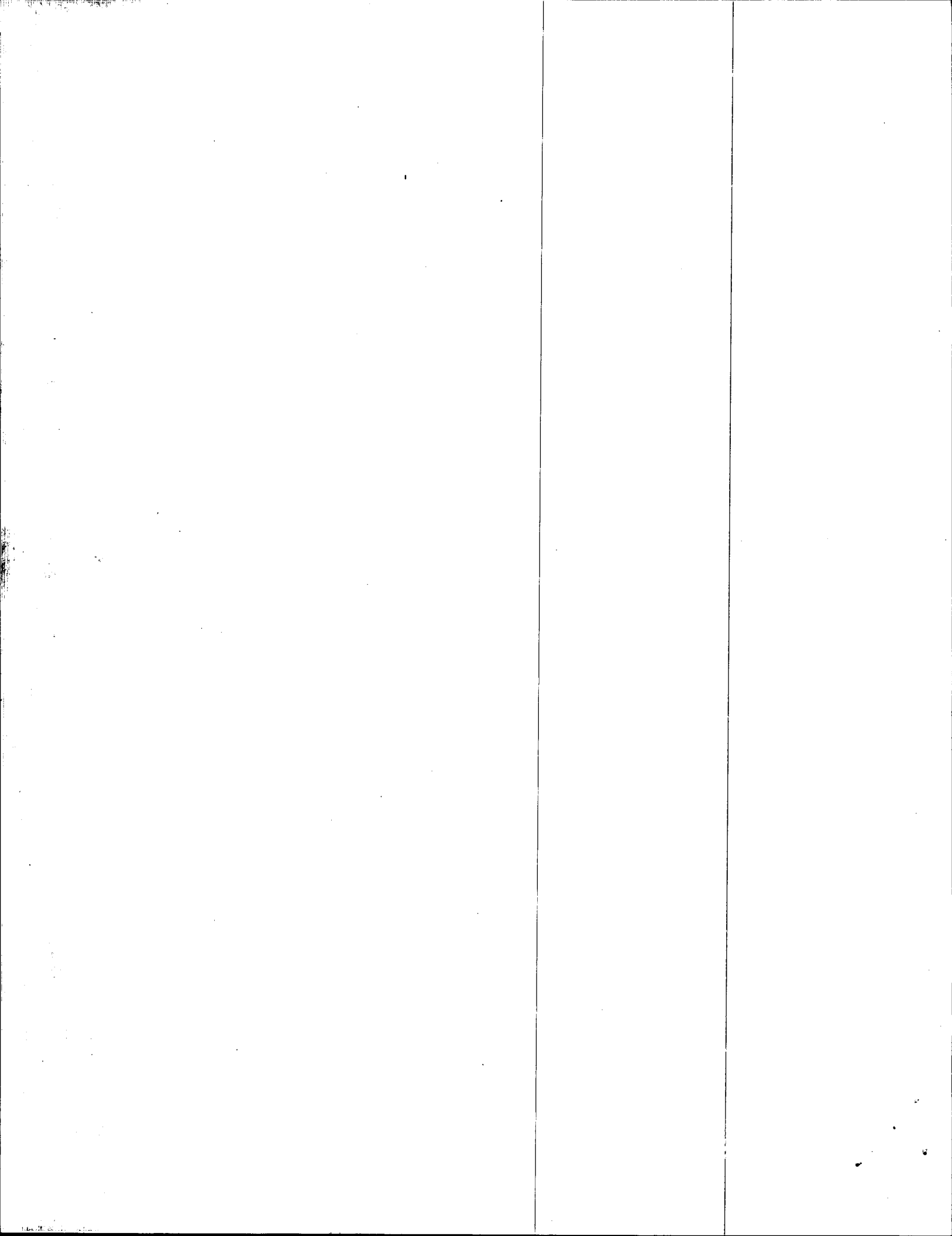
RELEASED  
-05-14-2009

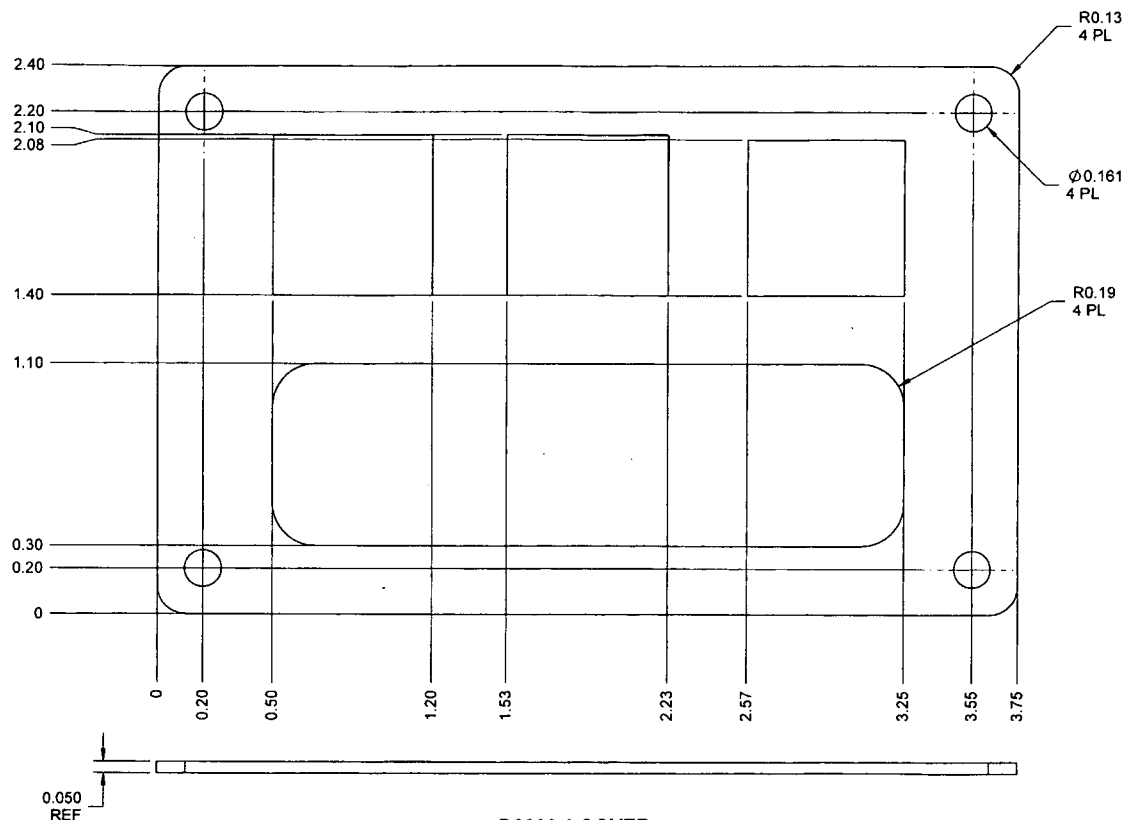
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.05.01
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.	N/A		
DATE	09.05.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A  
D3939 SHEET 1 OF 2  
TITLE SCALE  
COVER NTS

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**D3939-3 COVER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	D3939	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED  
-05-14 2009



# FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order:
Description: <i>Podet</i>		Part Number: <i>3939-3</i>
Inspection Dwg: <i>3939</i>	Rev: <i>4</i>	Page 1 of 1

☒ First Article   
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.20	±.030	1.201	—			<i>RA26 Jam</i>
	1.50	±.030	1.501	—			
	1.20	±.030	1.202	—			
	1.53	±.030	1.531	—			
	2.23	±.080	2.231	—			
	2.57	±.080	2.576	—			
	3.25	±.030	3.252	—			
	3.55	±.080	3.555	—			
	3.75	±.030	3.755	—			
	1.20	±.030	1.201	—			
	1.30	±.030	1.303	—			
	1.10	±.030	1.098	—			
	1.40	±.030	1.401	—			
	2.08	±.030	2.081	—			
	2.10	±.030	2.102	—			
	2.20	±.030	2.204	—			
	2.40	±.030	2.407	—			
	Ø.161	±.004	Ø.161	—			<i>RA26 Jam</i>

Measured by: <i>[Signature]</i>	Date: <i>12/02/15</i>
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Audited by: <i>[Signature]</i>	Date: <i>12/02/15</i>
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved	New Issue	KJULM
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17

97

17(2)

17